

Date: Tuesday, 12/20/2005 3:28:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services - Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 25312
 Estimate Number : 10265
 P.O. Number : N/A
 This Issue : 12/20/2005 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : 12/20/2005 Type : LANDING GEAR
 Previous Run : 25311
 Part Number : D350636012
 Drawing Number : D2750 REV C1
 Project Number : N/A
 Drawing Revision : C1
 Material : N/A
 Due Date : 1/20/2006 Qty: 1 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est Rev: 02.09.25 Rearranged procedure steps KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 001

DH 06/01/13 ①

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B23803

Pm 06-01-03 ①

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap

B23098

BE 06-01-05 ①

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end

Pm 06-01-03 ①

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330

Pm 06-01-03 ①

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size

Pm 06-01-03 ①

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-2), mark Fwd end for cutting using Drill Jig

Pm 06-01-03 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DT8150, then drill both sides.

5-Open holes as per detail "P" To 500", then Drill pilot holes to detail "B" using DT8329
Make sure that wearplate holes are on bottom of tube**

Pmc 06-01-03 ①

6-Open holes to .500" as per detail "B&C".

Pmc 06-01-03 ①

7-Open holes to .375" as per detail "D"

Pmc 06-01-03 ①

8-Cut fwd end of tube as per Dwg D2750

Pmc 06-01-03 ①

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

Pmc 06-01-03 ①

10-Open holes to .590" as per detail "D".

Pmc 06-01-03 ①

11-Deburr

Pmc 06-01-03 ①

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod

m 18901 BE 06-01-05

13-Grind welds flush as per Dwg D2750

BE 06-01-07 ①
a.m 06-01-09 ①

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-01-10 ①

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

5/DP 06-1-10 9/DP 06-01-10 ①

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2739

Web

B24403 Pmc 06-01-12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
8	D2743	Crossbolt spacer	B-24240 BE 06-01-17 ①

9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *a.m 06-01-11 ①*

2-Deburr and blow out all chips from inside of tube *a.m 06-01-11 ①*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 *m19131*

Sikaflex expire date: *06-06-20*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod *m19100 BE 06-01-17 ①*

5-Grind welds flush as per Dwg D2750 *pmc 06-01-18 ①*

6-Spot face ground handling holes AE0.750" (8 places) *pmc 06-01-18 ①*

7-Deburr holes *pmc 06-01-18 ①*

10.0	QC5/9	WELD INSPECTION
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Comment: Inspect weld and work to Step 20

PD 06-01-26

11.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

a.m 06-03-01

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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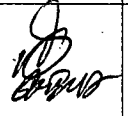
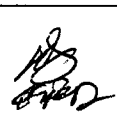
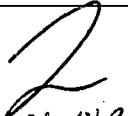
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FC 06-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-25	10	A pin hole was found on the out side of the fuel bend, of .050 x .030 deep		Repair hole as per attached e-mail. Inspect as Qc 9	BE 06-01-25	PD 06-01-26		 06-01-25

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Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 D27422 Blade Fitting, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, LH	246410

FC

14.0 AN835A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	m18576

FC

15.0 AN960JD816 1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	m6946

FC

16.0 MS21083N8 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	m185

FC

17.0 D26483 Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	024843 024843

FC

18.0 D265613 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	026324

FC 06 0228

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25312

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	624148

FC

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	624149

FC

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225	Insert	m14526
	(or AKS4-1032-225)		
	(or ALS7-1032-225)		
	(or AKS7-1032-225)		

FC

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	m19185

FC

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	m14526

FC 02 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25312

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0	AN36A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	m19185

FC

25.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	0241146

FC

26.0	AN644A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	m19185

FC

27.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	m17614

FC

28.0	AN332A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-32A	Bolt	m18406

FC 060228

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25312

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	A3235020935	Washer - Countersunk
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	A3235-020-935	Plug	m18332

30.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L3	Nut	m6931

31.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	m19185

32.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	m16066

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned. FC

A/R Sikaflex-291 m19597

Sikaflex expire date: 06 18 06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT. FC

A/R Sikaflex-291 m19597

Sikaflex expire date: 06 18 06

06 02 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25312

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

3-Install D2745 Bushing as per Dwg. D2750 Detail M

FC

4-Install A3235-020-935 Plug as per Dwg. D2750 Detail L

FC

06 02 28

5-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

FC

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mm

68 03 06

①

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

36.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2741

Blade

B24750

37.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

M6956

38.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 MS21083N8

Nut

B2 M19099

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25312

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

39.0 AN816A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

M5760

P 6/3/04

40.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CL 06/03/07 (1)

41.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev 2 P 6/3/07 (1)

42.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/03/08 (1)

Job Completion



U 06/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.12.16 DS

DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
CI	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44	44	44	44	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT
42	42	42	42		

EFFECTIVE	DEOS
880 4133 DS	880 4137 DS
98.01.19 DS	98.10.21 DS

25312



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

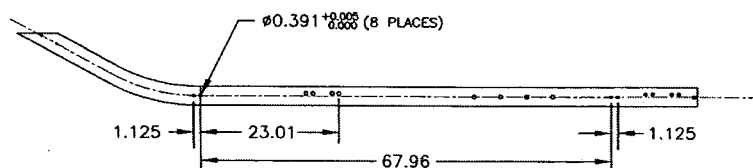
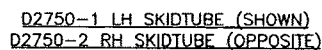
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

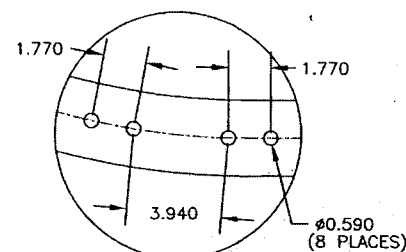
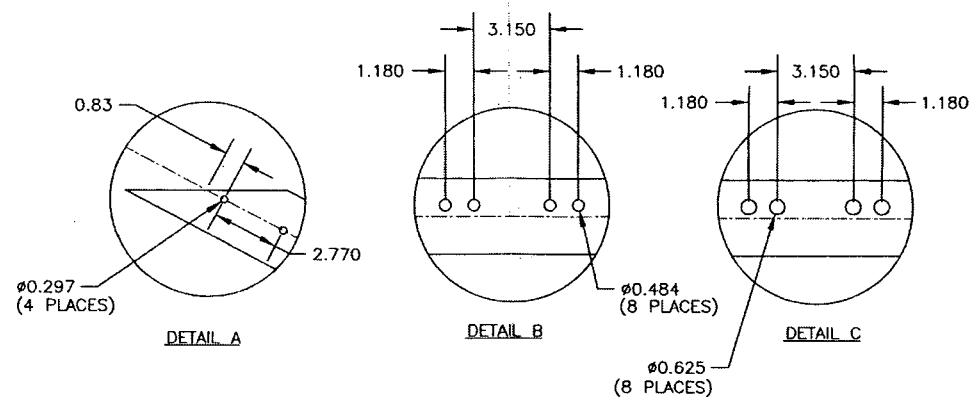
EFFECTIVE	DEOs
DEO 4133 98.01.19 DS	DEO 4157 99.10.21 DS

RELEASED
99.12.16 DS

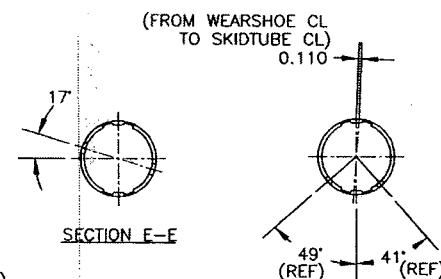
NO COPY
NO MORE
NO MORE



D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)
D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES
ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



DETAIL D
(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)



SECTION F--F

RELEASE
98.12.16 DS

EFFECTIVE	DEOs
000 9133 98.01.19 DS	000 9157 99.01.21 DS

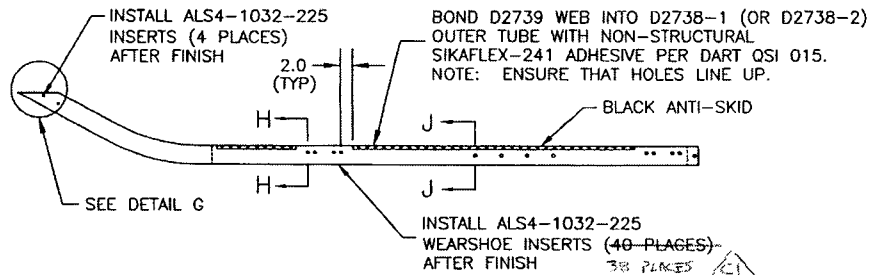
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART DART AEROSPACE USA, INC. BELLUVE, WA	REV. C
CHECKED <i>PH</i>	APPROVED <i>HE</i>		SHEET 3 OF 4
DATE 98.11.18	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20	

WORK OF THE
SUBJECT IN
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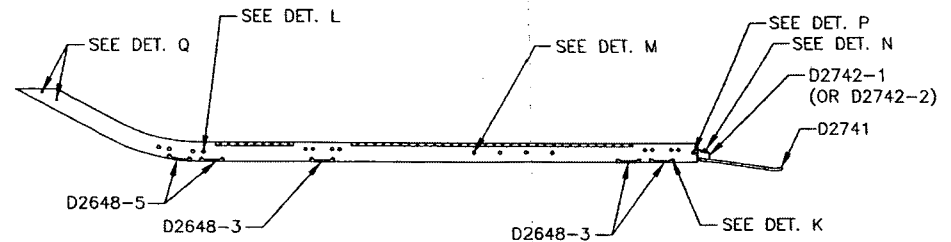
COPY
GME
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NO 85312

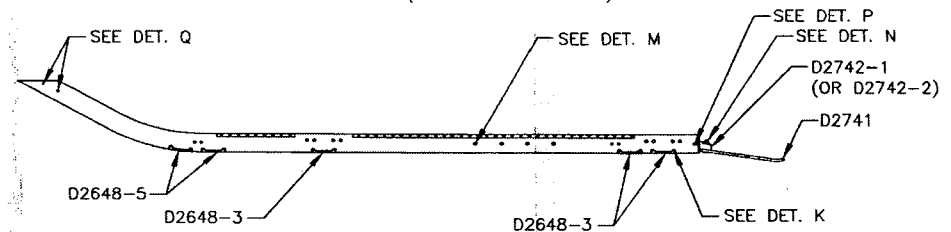
D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



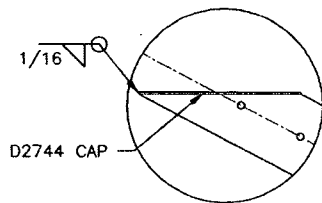
D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



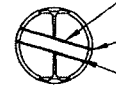
D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



DETAIL G



SECTION H-H



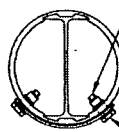
SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

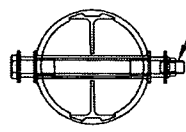
DETAIL K



USE AN3-6A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD

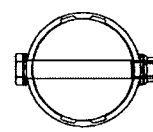
AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
(42 PLACES)

DETAIL M



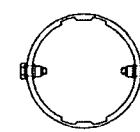
AN6-44A BOLT (1)
D2745 BUSHING (2)
MS21042L6 NUT (1)
(4 PLACES)

DETAIL P



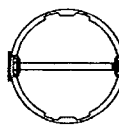
AN8-35A BOLT (1)
AN960JD816 WASHER (2)
MS21083N8 NUT (1)

DETAIL Q



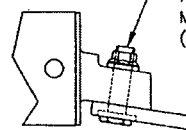
AN3-6A BOLT (1)
AN960JD10 WASHER (1)
(4 PLACES)

DETAIL L



AN3-32A BOLT (1)
A3235-020-935 PLUG (2)
MS21042L3 NUT (1)
(4 PLACES, FOR D2750-041/-042 ONLY)

DETAIL N



AN8-16A BOLT (1)
AN960JD816 WASHER (1)
MS21083N8 NUT (1)
(2 PLACES)

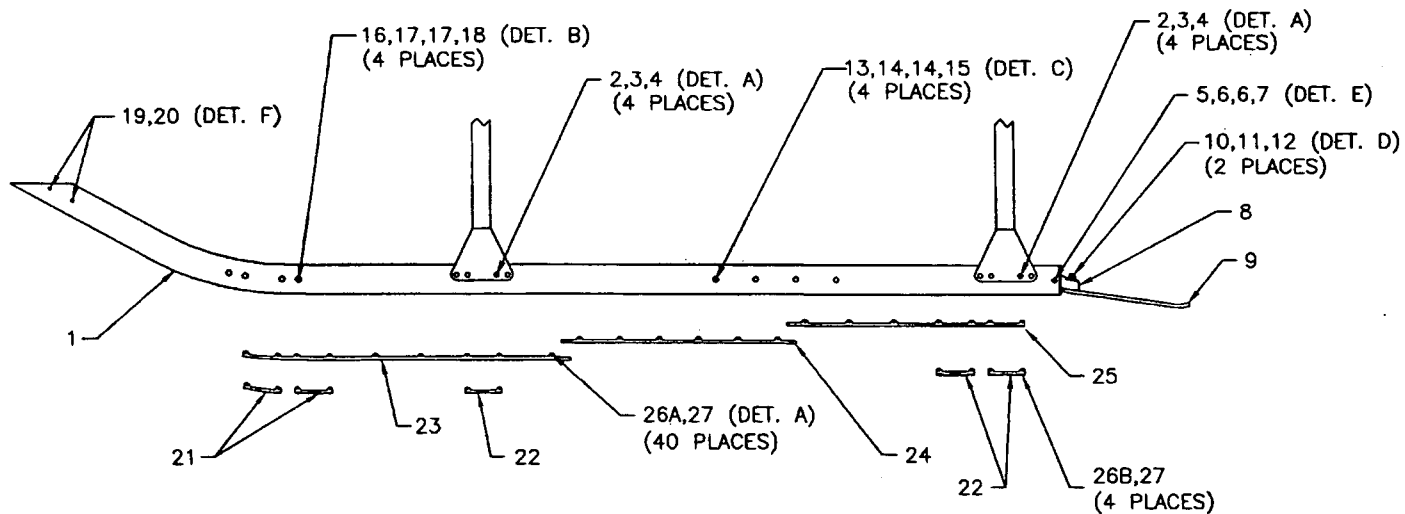
EFFECTIVE	DEOs
DES 9133 98.01.19 DS	DES 9157 99.10.21 DS

DESIGN 98	DRAWN BY CP	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED 98	APPROVED KE	DRAWING NO. D2750
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY
		REV. C SHEET 4 OF 4 SCALE 1:20

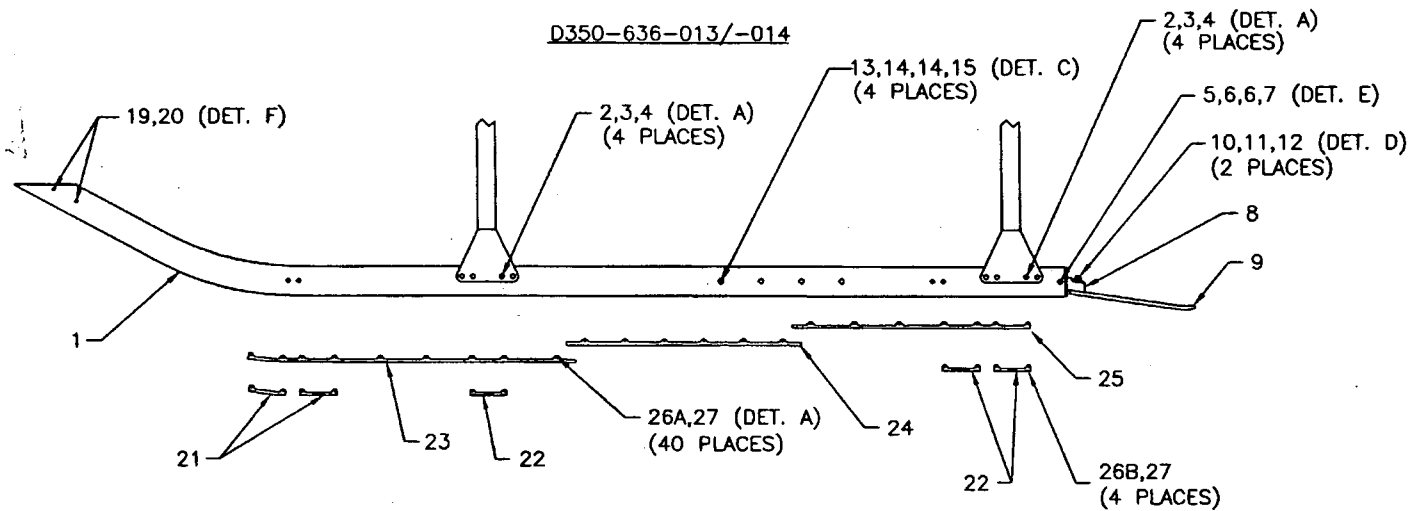
RELEASED
98.12.16 DS

25312
ORDER
NOTICE
ROLLED COPY
AMENDMENT

D350-636-011/-012



D350-636-013/-014



25312

Jason Murdoch

From: David Shepherd [davids@dartaero.com]
Sent: January 25, 2006 9:54 AM
To: Jason Murdoch
Subject: Re: 350 skid

It is acceptable to fill this gouge with weld per QSI 004 and grind flush.

David

----- Original Message -----

From: Jason Murdoch
To: davids@dartaero.com
Sent: Wednesday, January 25, 2006 3:41 AM
Subject: 350 skid

If you look at the pics. The hole is about .050 wide x .030 deep, in the fwd section of the bend. Can we open this hole a little to clean it up and weld it up? Is this acceptable to do this in the bend?

jmurdoch@dartaero.com

Q.C. Inspector